

*Work Order ID 139218

November 16, 2015 3:39:56 PM

139218

To ship Jan 11/16

Page 1

Item ID: D412-761-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Instrument Panel

Stop *NS2*

Start Date: 11/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SH Date: 20151116 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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IIN D412-761	E
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100

Document Control

0.00

100

DOCUMENT CONTROL

BAS

27

9-89

JAN 11 2016

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-761-047 CHG002

110

Pick Kit

0.00

110

BAS

27

9-89

JAN 11 2016

Packaging

Memo

0.00

Packaging

DEC 15 2015

28

9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

BAS

27

9-89

JAN 11 2016

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Work Order ID 139218

November 16, 2015 3:39:57 PM

139218

Page 2

Item ID: D412-761-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel

Start Date: 11/16/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-047								
	Location: <u>20</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JAN 11 2016

JAN 11 2016

JAN 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 139218

139218

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 11/16/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC 13.01.15 as per ECN13-511 DD Verf:JLM IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A Bolt		Purchased	No			110	Each	96.0000	4	4			DAS 6 9-89
AN3-4A													
**													
DAS 27 9-89 <u>Location</u> ST350 m129682 m133234 <u>Loc Qty</u> 96 13 83 <u>Loc Code</u> 													
D3705-11 Main Panel		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D3705-11													
**													
DAS 27 9-89 <u>Location</u> ST052 105314 <u>Loc Qty</u> 6 6 <u>Loc Code</u> 													
D3705-7 Main Panel		Manufactured	No			110	Each	6.0000	1	1			DAS 6 9-89
D3705-7													
**													
DAS 27 9-89 <u>Location</u> ST052 110932 <u>Loc Qty</u> 1 1 <u>Loc Code</u> 													
D3705-9 Panel		Manufactured	No			110	Each	1.0000	1	1			DAS 6 9-89
D3705-9													
**													
DAS 27 9-89 <u>Location</u> ST052 110932 <u>Loc Qty</u> 1 1 <u>Loc Code</u> 													

139 238

DAS
6
9-89
JAN 06 2016

DEC 15 2015

Picklist Print

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Work Order ID: 139218

139218

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 11/16/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

D4758-1 Manufactured No

110 Each 6.0000 2 2

D4758-1

Blanking Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

ST123

6

105692

4

107497

2

DAS
28
9-89

D4758-3 Manufactured No

110 Each 3.0000 3 3

D4758-3

Blanking Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

ST123

3

116015

3

DAS
28
9-89

NAS1149D0332J Purchased No

110 Each 2,461.000 10 10

NAS1149D0332.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

78

m129682

78

GA

369

m132677

369

ST264

2000

m133498

2000

DAS
28
9-89

D3705-041 Manufactured No

110 Each 1.0000 1 1

D3705-041

Instrument Paney Assy

DAS
27
9-89

Location

Loc Qty

Loc Code

ST373

1

134053

1

DEC 15 2015

DAS
28
9-89

DAS
28
9-89

November 16, 2015 3:40:08 PM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 139218

139218

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 11/16/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

D3707-1 Manufactured No

110 Each

0.0000

2

2

**

D3707-1

Mounting Lug

D3790-1 Manufactured No

110 Each

2.0000

1

1

**

D3790-1

Indexing Block

Location

Loc Qty

Loc Code

ST054

2

105301

2

D3867-1 Manufactured No

110 Each

3.0000

1

1

**

D3867-1

Connector Plate

Location

Loc Qty

Loc Code

ST055

1

134056

1

ST063

2

103733

2

AN526C1032R6 Purchased No

110 Each

386.0000

6

6

**

AN526C1032R6

Screw

Location

Loc Qty

Loc Code

ST327

386

1892

386

AN743-12 Purchased No

110 Each

28.0000

2

2

**

AN743-12

Clip

Location

Loc Qty

Loc Code

ST330

28

M126175

10

M127124

18

DAS

6

9-89

DAS

28

9-89

134309

DAS

6

9-89

DAS

28

9-89

BAS
27
9-89

DAS

6

9-89

DAS

28

9-89

BAS
27
9-89

DAS

6

9-89

DAS

28

9-89

BAS
27
9-89

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

DEC 15 2015

Picklist Print

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Work Order ID: 139218

Parent Item: D412-761-047

Parent Item Name: Instrument Panel

139218

D412-761-047

Start Date: 11/16/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21075L3 MS21075L3N Purchased No

110 Each 78.0000 6 6

MS21075L3

Nut Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

ST298

78

M131153

78

MS24693-C272

Purchased No

110 Each 1,088.000 4 4

MS24693-C272

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

cck007a

986

17137

467

17831

519

ST291

102

9370

102

MS27039-1-17

Purchased No

110 Each 220.0000 1 1

MS27039-1-17

Screw (601.1954)

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

187

120142

37

m127831

150

ST285

33

m127305

30

m130388

3

MS27039-1-27

Purchased No

110 Each 41.0000 1 1

MS27039-1-27

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

41

110606

41

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Shop Packet Print

Page 4

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DEC 15 2015
DAS
28
9-89

Picklist Print

November 16, 2015 3:40:09 PM

Page 5

Work Order ID: 139218

Parent Item: D412-761-047

Parent Item Name: Instrument Panel

139218

D412-761-047

Start Date: 11/16/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

529.0000

4

4

MS21042L3

Nut

**

M133790

DAS

8

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

FP001

300

M130922

300

GA

90

M131317

90

ST304

139

M133498

139

DAS
27
9-89

MS21919-WDG8

Purchased

No

110

Each

96.0000

2

2

MS21919-WDG8

Clamp

**

Location

Loc Qty

Loc Code

ST293

96

m128057

96

DAS
27
9-89

DAS

8

9-89

DEC 15 2015

DAS

28

9-89

Work Order ID 139218

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139218

Page 1

To ship Jan 11/16

Item ID: D412-761-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Instrument Panel

Stop *NS2*

Start Date: 11/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

SH

Date:

20151116

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-761

E

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-761-047 CHG002

ML5 DEC 16 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DEC 15 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

REFERENCE ONLY

DART AEROSPACE LTD.

BAS

27

9-89

(CONTINUED FROM PAGE 10)

IIN-D412-761

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QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
				1				D3705-041	INSTRUMENT PANEL ASSEMBLY
				1				D3705-043	* INSTRUMENT PANEL WELDMENT
				1				D3335-1	* SPRING
				1				D3705-5	* ACCESS PANEL
				1				D3706-041	* LOCK BRACKET ASSEMBLY
				1				D3706-5	* PIN
				2				D3707-3	* MOUNTING LUG
				2				AN3-3A	* BOLT
				4				AN526C1032R6	* SCREW
				1				MS171498	* SPRING SLOTTED PIN
				4				MS24693-C272	* SCREW (OR MS24693-S272)
				2				NAS1149D0332J	* WASHER (OR AN960JD10L)
				1				NAS1149D0563J	* WASHER (OR AN960JD516)
				1				D3705-7	FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-9	FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-11	FACE PLATE (FOR 212, 214, 412, MODELS)
				2				D3707-1	MOUNTING LUG
				1				D3790-1	INDEXING BLOCK
				1				D3867-1	CONNECTOR PLATE
				2				D4758-1	BLANKING PLATE
				3				D4758-3	BLANKING PLATE
				4				AN3-4A	BOLT
				6				AN526C1032R6	SCREW
				2				AN743-12	BRACKET
				6				AN960JD10L	WASHER
				6				MS21075L3	NUTPLATE (OR MS21073-3)
				4				MS24693-C272	SCREW (OR MS24693-S272)
				1				MS27039-1-17	SCREW
				1				MS27039-1-27	SCREW
				4				MS21042L3	NUT
				2				MS21919WDG8	CLAMP
				4				NAS1149D0332J	WASHER (OR AN960JD10L)
					1	1		D3694-041	MOUNTING PLATE ASSEMBLY
					1	1		D3694-1	* KEYWAY
					1	1		D3694-3	* PROTECTIVE PLATE
					1	1		D3694-5	* MOUNTING PLATE
					1	1		AN526C1032R8	* SCREW
					4	4		MS21042L3	* NUT
					2	2		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					1	1		MS24693-C271	* SCREW (OR MS24693-S271)
					4	4		MS24693-C273	* SCREW (OR MS24693-S273)
					5	5		NAS1149D0363J	* WASHER (OR AN960JD10)
					1	1		D3695-041	SLIDER ASSEMBLY
					1	1		D3695-1	* SLIDER
					1	1		D3695-3	* STOPPER
					1	1		MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS24693-C276	* SCREW (OR MS24693-S276)
					1	1		D3801-1	* HAND RETRACTABLE SPRING PLUNGER

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 12)

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Revision: **E**

Date: 12.12.07